



Dart Aerospace Ltd.
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Canada

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D2596**Job Sheet 201244****Part No:** D2596**Job Qty:** 10 pcs**Part Name:** Web, 205 Skidtube**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 9/27/19**Job Tracking No:****Due Date:** 10/21/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV D IPP: D 99.02.02 Changed QA to QC, Added Step 6 and Cost DM IPP Rev:E 07-07-09
Incorporated DEO 9183 JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs Run Hrs	Workcenter/Supplier		Sign-off
						Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	10 pcs	10/21/19		0.00 5.32	Skidtubes - 1		
						Skidtubes - 2		
						Skidtubes - 3		
						Skidtubes - 4		TF
						Skidtubes - 5		
						Skidtubes - 6		
						Skidtubes - 7		
110	Handfinish - 1-1 Chemical- B4B	10 pcs	10/21/19		0.00 2.62	Handfinish - 1 - 1 - B4B		BEB19-10-09
						Handfinish - 1 - 2 - B4B		
						Handfinish - 1 - 3 - B4B		
						Handfinish - 1 - 4 - B4B		
						Handfinish - 1 - 5 - B4B		
						Handfinish - 1 - 6 - B4B		
						Handfinish - 1 - 7 - B4B		
						Handfinish - 1 - 8 - B4B		
						Handfinish - 1 - 9 - B4B		
						Handfinish - 1 - 10 - B4B		
						Handfinish - 1 - 11 - B4B		
						Handfinish - 1 - 12 - B4B		
						Handfinish - 1 - 13 - B4B		

**Container No:** S220732**Part:** D2596**Job No:** 201244**Serial No/Batch:** S220732**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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CANADA
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Date: 10/08/19

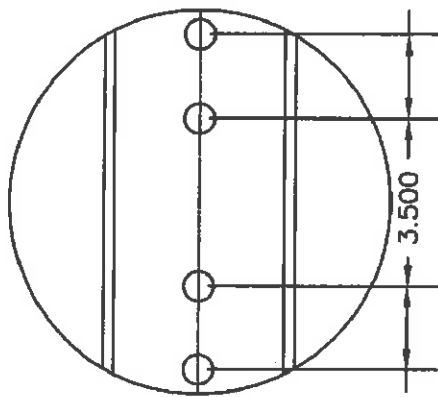
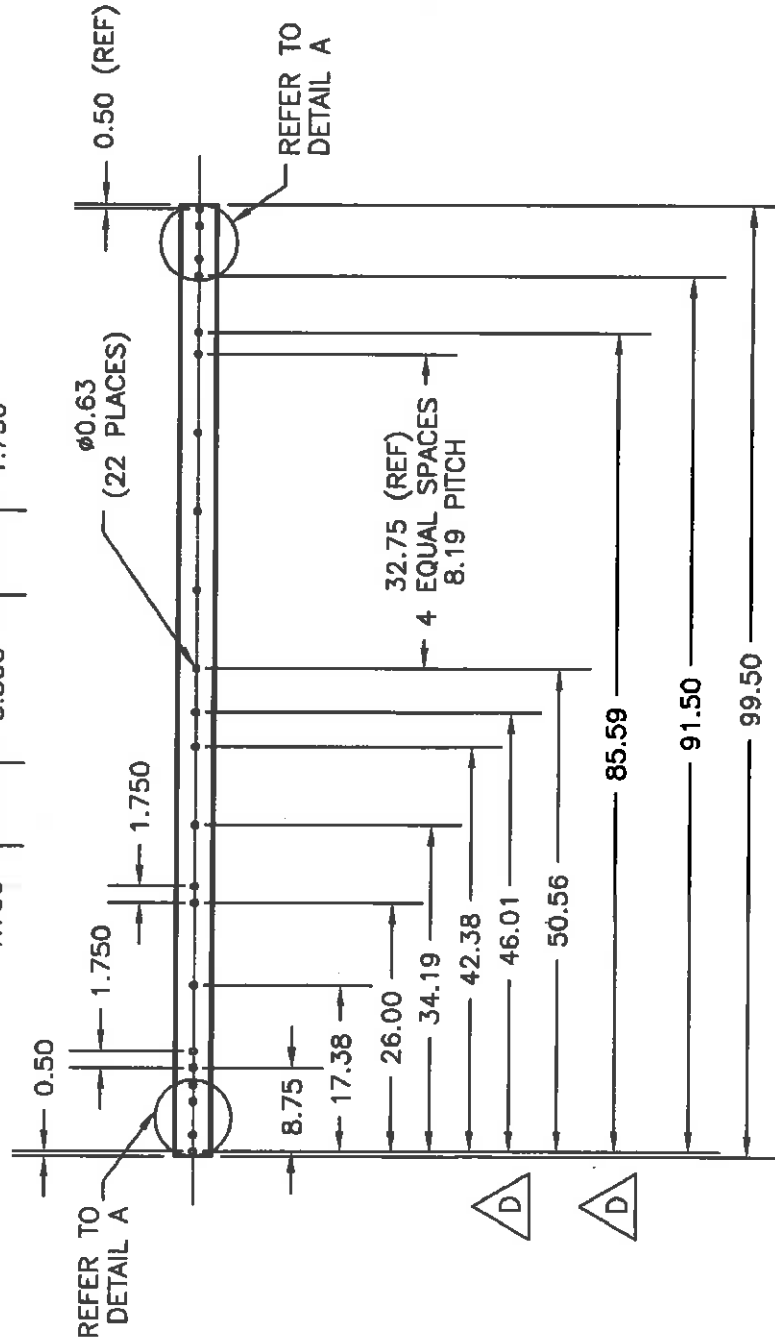
Plex 9/27/19 1:28 PM Dart.lajeunesse.marie

						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
						QC 5 - 10	
120 QC 5	10 pcs	10/21/19	0.00	0.00		QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	BE
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
130 Packaging 3-1 - Stock - B4B	10 pcs	10/21/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 -	

				B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	TF
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS 21 9-28
140 QC 21 - SA	10 pcs	10/21/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Descriptions: Dwg D2596 4- Deburr 110 - (Chemical Conversion Coat per QSI005 4.1) 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: <u>16002</u>) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2500-3-100	Ext'n - I' Beam Web 4"	10 pcs (1 ea)	100-Skidtubes - 1	5166539	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Skidtubes - 1	D2500-3-100	10	139	0	
Part Specifications					
Specifications could not be found.					

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

RELEASED
07.06.28**DETAIL A**
SCALE 1:4**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS					
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	MRB (QS1042) ☐	
Date: _____	Sequence #: _____	QTY Affected: _____				Completed By _____	
Description Work Order Deviation		Disposition				Lead hand / Supervisor _____	
						QC / QA Coordinator _____	
Root Cause		FAULT CATEGORY					
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐			
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐			
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐			
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐			
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐				
Human Factors ☐	Other/Details: _____						